Work Order ID 10 May-01-13 7:29:02 AM	00875	· .	*100	1875*	· .					Page	1
tem ID: D2324-3 Revision ID:			Accept	*N900	<u>040</u>	100)* s	etup Star	* *N	S1*	
tem Name: Bar	<i>.</i> *							Stop	*N	S2*	
Start Date: 4/30/13 Required Date: 4/30/13	Start Qty: 8.00 Req'd Qty: 8.00	*8*		Cust Item I	D:						
Reference:	Key u Qiy. 8.00	*8*		Customer:							
Approvals: Process Pl	an: _ <u>从</u> して	Date: \3-05-0	Tooling:	Da	ıte:		R	tun Star Sto _l	17	R1*	
QC:	••	Date:	SPC (Y/N):	Da	ıte:			Sto	" *N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr Re	vision Nbr										
D2324 Re	v C			IN H 12 (e 15		8	(X			
[∞] *1∩∩*	BAND SAW		0.00	17H 13/0	15/13			γ			_
Bandsaw easpa Bandsaw	Memo Cut blanks:	(0.75" x 0.75") x 5.75" Lor	0.00 ng Bar								
-			•				ب	,¢			
10	WAAR ONG WEDTICAL	MACHINING #1	0.00	h / 1014	0 13/05	114	ž.				
110 haas i	HAAS CNC VERTICAL Memo	, MACHINING #1	0.00	D. A MUF	17/07/	77	_8	- D			-
HAAS CNC vertical machine #1		as per Folio D2324-3 and I p edgesIdentify as D2324		d Tumble, to							
, ,			•			•		e i			
*120	QC2- Inspect parts off m	achine FAI/FAIB	d 0.00	B.a MJP	13/05/	14	8	o de la companya della companya dell			
QC	Memo		0.00	•				<i>y</i>			-

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UF	PDATE			
											QA Closed:	Date:	
Work Ord	oŕ.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	-
VVOIROIU	C1.					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part	Nο					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				:		Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	
						٠ ـ ـ	_			·			. <u> </u>
Root		,	T T		Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data							1						
Equip/Tooling											l i		
Operator			j .										
Material	L_		İ										
Setup	匚												
Other					·								
Process	L												
Supplier	L									•		·	
Training	_												
Unapproved	<u>L</u>		<u> </u>										
							FAUI	LT CATE	GORY		···········		
Land	ing (7			_	General		٦			1		l_
	-	Bending				Bend	\vdash	Grain			Ovalized		Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		_	Over/Under	<u> </u>	Temperature/Cure
	-	Cracks			<u> </u>	Broken/Damaged	-	⊣ `	on Incomplete		Part Incorre	—	Weld
	\vdash	Crushed/	Crimped		<u> </u>	Burrs	1	-	ions Incomplete,	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	<u></u>	Cuffs			_	Contamination	\perp	Mainte		ļ	Part Moved		
	<u></u>	Heat Tre			\vdash	Countersink	<u> </u>	Mislabe		·	Positioned V		l
1	1	Inspection	n Strip in	Tube	I	Cut Too Short	-	Misread	j		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

8 B.5-15.



										DQA.		не	
NCR: Y	es /	No			WORK ORDER NON-O	COI	NFOR	MANCE / UPDATE		QA Closed:	Da	ite:	
			i		DISPOSITION			AGAIN	ST DE	PARTMENT	***		
Work Orde Part N NCR N	lo	.,			Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstul Machining Small Fa noforming Finishin Large Fab Composi	ab ng	4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root	···		·	Descri	ption of work order update	<u>.</u>	Initial	Action		Sign &			
Cause	Da	ite Step	Qty	1	or Non-conformance	1	nief Eng			Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					÷7.(J								
	·	·		···		AUI	LT CATE	GORY					
Landi	Crac	re Not Conc		o/s	General Bend BOM/Route Broken/Damaged Burrs		4 '	ire ion Incomplete tions Incomplete/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuff	•			Contamination	\vdash	Mainte	•		Part Moved	-	_	_

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Work Order ID 100 May-01-13 7:29:02 AM		00875				Page 3					
Item ID: Revision ID: Item Name:	D2324-3 Bar			Accept	*N900	040	100)* s	etup Star Stop	IV	S1* S2*
Start Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:			·		.*
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Star Stoj	₀ . i∕Л	R1* R2*
Sequence ID/ Work Center II 160 *160* Packaging Packaging	D	Operation Description Identify as per dwg & St	ock Location	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					13/5	121	105-17
									, jvi		

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					,	Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.	<u> </u>			·	Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update		Initial	Act	ion	Sign &	વર્લ	
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												,	
Equip/Tooling			}										
Operator													·
Material							l						
Setup							1						
Other													
Process													
Supplier													
Training													
Unapproved							<u> </u>					<u></u>	<u> </u>
						F	AUL	LT CATE	GORY				
Landi	ng (Gear			_	General		_			,	_	
		Bending			. L	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	L	Cracks				Broken/Damaged		Inspecti	on Incomplete	<u></u>	Part incorre	ct _	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
l	Γ	l Rinnles in	. Bend		ſ	Drill Holes	Г	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

May-01-13 7:29:02 AM

Work Order ID: Parent Item:

100875

Parent Item Name:

Bar

D2324-3

Start Date: 4/30/13

Required Date: 4/30/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:	IPP: E03.02.28R	Reformat; Incorpo	rated D232	24-3 & D2324	-5KJ/RF								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.750 6061-T6 Bar .750 x .750		Purchased	No			100	f	5.2220	0.53	4.463157	6		

Location Loc Qty Loc Code MAT049 5.222 121836 0.712 -124443 4.51

MA 13/03/13 4.025

NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORM	MANCE / UPI	DATE			
									<u>•</u>		QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	· · · · · · · · · · · · · · · · · · ·
Part I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	nitial		ion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	Ц											·	
Equip/Tooling	Ш												
Operator	Ш								•				
Material	Ш												
Setup	Н												
Other	Ц												
Process	Н											,	
Supplier	Н		ļ										
Training	\vdash												
Unapproved			<u> </u>	<u> </u>			<u> </u>	T CATE	CORY		J		<u> </u>
Landi	G					F	AUL	CATE	GORT				
Lanui		Bending			Г	Bend	П	Grain	·	Г	Ovalized	<u> </u>	Pressure/Forced
		Centre No	nt Conce	ntric to		BOM/Route	\vdash	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
i	\vdash	Cracks	or conce	ittiic to	°,	Broken/Damaged	\vdash		ion Incomplete		Part Incorre	<u> </u>	Weld
	-	Crushed/	Crimped			Burrs	-		ions Incomplete/l	Jnclear	Part Lost/M		Wrong Stock Pulled
	\blacksquare	Cuffs	p		<u> </u>	Contamination		Mainte	•		Part Moved	· L	
	-	Heat Trea	at			Countersink	П	Mislabe	eled		Positioned V	Vrong	
	-	Inspectio		Tube	<u> </u>	Cut Too Short	П	Misread	d		Power Loss/	Surge	Other
	-	Ripples in	-			Drill Holes		Offset			-		
	\vdash	Torque W		Extrusio	n	Drawing		Out of 0	Calibration				
	П	Turning S	equence			Finish	П	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

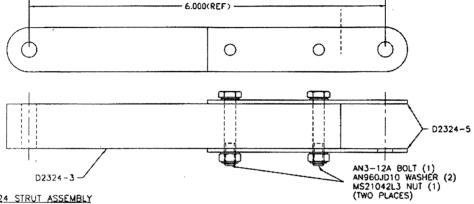
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DESIG B W	N /ILLIAMS	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		
CHECK		APPROVED	DRAWING NO.		REV. C
	#	#	D2324	SHEET	1 OF 1
DATE			TITLE		SCALE
04.1	2.14		STRUT		
Α		94.11.08	NEW ISSUE		
В		96.05.07	UPDATE MATERIALS		

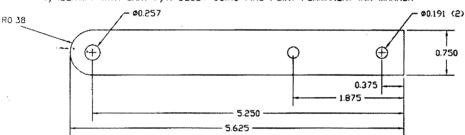
RELEASED 04.12.16

04.12.14 UPDATE NOTES C



D2324 STRUT ASSEMBLY

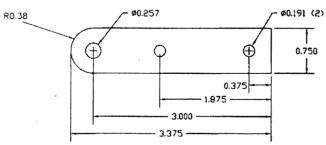
1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



- D2324-3

 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T680.750X00.750)

 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



02324 - 5

- AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA) 1) MATERIAL:
- POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI D18 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order: 100 8 7 5
Description: Bar	Part Number: // _23_24~3
Inspection Dwg: D2324 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0,257	+ 0,006	0,258	/		MJP-04	Vern
00,191	+ 0,005	0,193	/		111	111
0,375	+ 0,010	0,377	V		111	///
1.875	+ 0.010	1,877	V		111	111
5, 250	+ 0010	5,249	V		/ / /	111
0.750	+ 0.010	0,755	/		111	111
5, 250 0, 750 R 0,375	+ 0,030	0,375	V			Rudius Gage
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Measured by: Dig MUP	Audited by: Physics 104	Preliminary Approval:	
Date: 13/05/14	Date: 13/05/14	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15